

Work Order ID 126538 ⁴

Thursday, November 13, 2014 8:31:23 AM

126538

Ship NOV. 21

Page 1

Item ID: D3779-043

Revision ID:

Item Name: Handle Assembly (Interior)

Start Date: 11/17/14

Start Qty: 25.00

Required Date: 11/20/14

Req'd Qty: 25.00

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date: 14-11-12

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3779

C

100

100

Waterjet

FLOW CNC Waterjet

6061.125

FLOW WATER JET

0.00

Memo

0.00

1-Cut D3779-5 as per Dwg D3779

Dwg Rev. C

Prog Rev. C

2-Deburrif necessary

DAS

23

9-89

14-11-13

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

DAS

23

9-89

14-11-13

120

120

QC

Quality Control

QC8- Inspect parts second check

0.00

Memo

0.00

DAS

38

9-89

NOV 13 2014

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Page 2

Item ID: D3779-043

Revision ID:

Item Name: Handle Assembly (Interior)

Start Date: 11/17/14 Start Qty: 25.00

Required Date: 11/20/14 Req'd Qty: 25.00

Reference:

Accept

N9000040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Small Fab

Small Fab

Small Fab

Memo

1- counter sink holes as per dwg D3779
2- deburr

0.00

0.00

28

14/11/17

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

28

38
9-89

NOV 17 2014

150

150

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

28. 14-11-18

DAS 34
9-89

Work Order ID 126538

Thursday, November 13, 2014 8:31:23 AM

126538

Page 3

Item ID: D3779-043

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Handle Assembly (Interior)

Start Date: 11/17/14 Start Qty: 25.00

25

Cust Item ID:

Required Date: 11/20/14 Req'd Qty: 25.00

25

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

QC7-Inspect Chemical Conversion Coat

0.00

160

QC

Memo

0.00

DAS
30
9-89

48

12/21/06

Quality Control

180

Small Fab

0.00

180

Small Fab

Memo

0.00

8

FF

JAN 07 2015

Small Fab

1 - rivet D3203-1 handle to D3779-5 plate as per dwg D3779 per QSI003

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

DAS
38
9-89

8

Quality Control

JAN 07 2015

Work Order ID 126538

Thursday, November 13, 2014 8:31:23 AM

126538

Page 4

Item ID: D3779-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Handle Assembly (Interior)
 Start Date: 11/17/14 Start Qty: 25.00 ***25*** Cust Item ID:
 Required Date: 11/20/14 Req'd Qty: 25.00 ***25*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

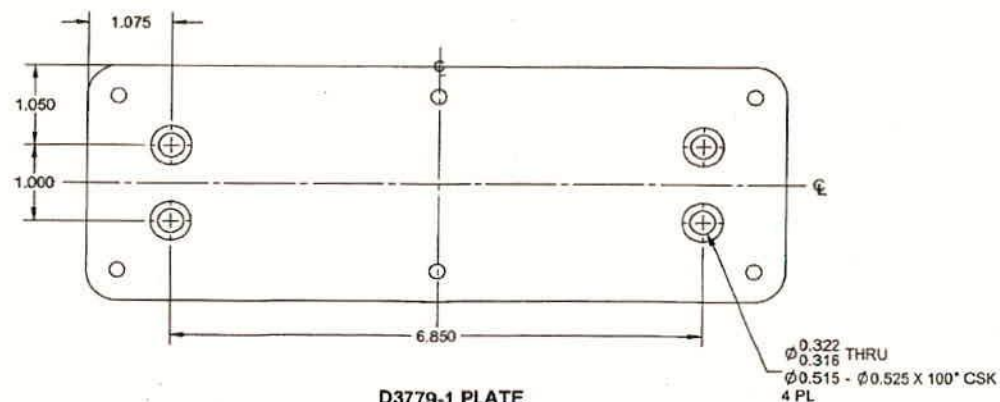
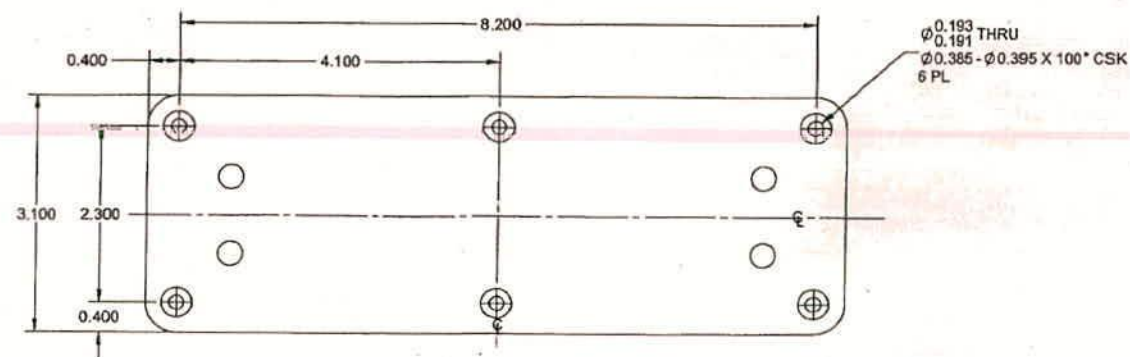
Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200 *200* Packaging Packaging	Identify as per dwg & Stock Location: ST SLS	0.00 0.00				8	DAS 86 8-89		
210 *210* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				MLJ	1501-07		JAN 07 2015

15-1-7

Thursday, November 13, 2014 8:31:30 AM

100

32



D3779-1 PLATE

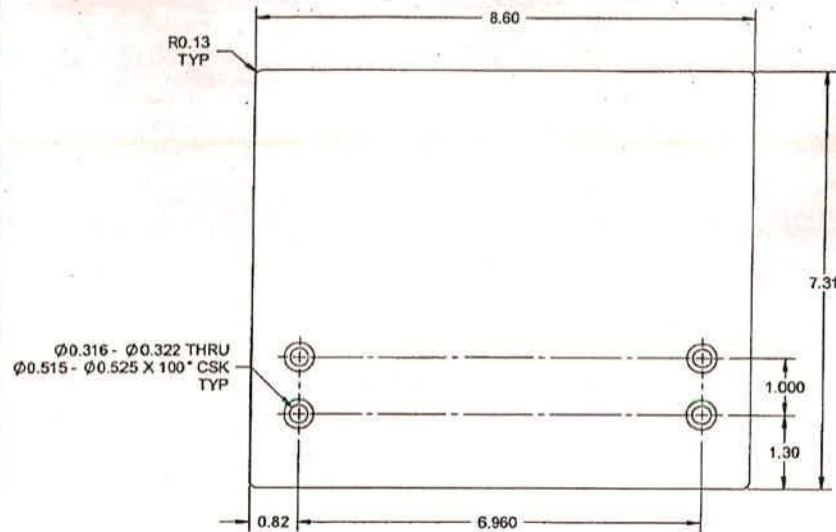
RELEASED
2012-07-23
MJB

NOTES:

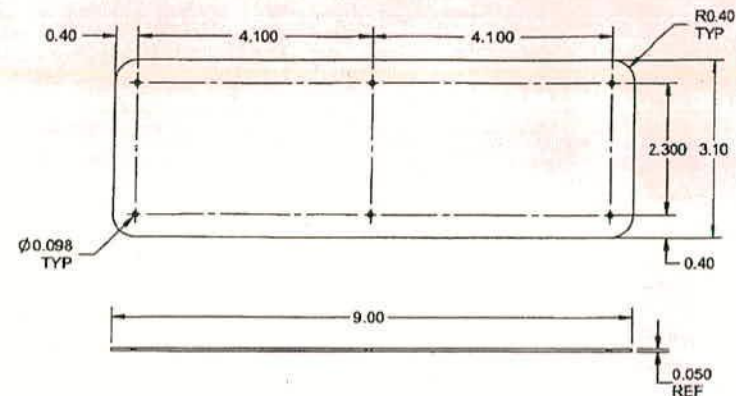
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK
PER AMS-QQ-A-250/11 OR AMS 4027
(REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.33 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	A.P.	DRAWING NO.	REV. C
MFG. APPR.	50	D3779	SHEET 3 OF 4
APPROVED	MJB	TITLE	SCALE
DE APPR.	10	HANDLE ASSEMBLY,	NTS
DATE	12.04.26	CABIN SLIDING DOOR	

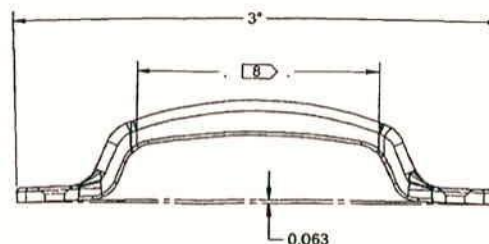
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D3779-5 PLATE



D3779-3 DOUBLER PLATE



D3779-7 HANDLE, MODIFIED

NOTES:

1) MATERIAL:

D3779-3: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF DART SPEC M6061T6S.050)

D3779-5: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK
PER AMS-QQ-A-250/11 OR AMS 4027
(REF DART SPEC M6061T6S.125)

D3779-7: MADE FROM D3203-1

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: D3779-3: IDENTIFY WITH DART P/N "D3779-3" AND B/N "BXXXXX" PER DART QSI 044 6.1

D3779-5: NONE
D3779-7: NONE

7) WEIGHT: D3779-3: 0.14 lbs

D3779-5: 0.76 lbs

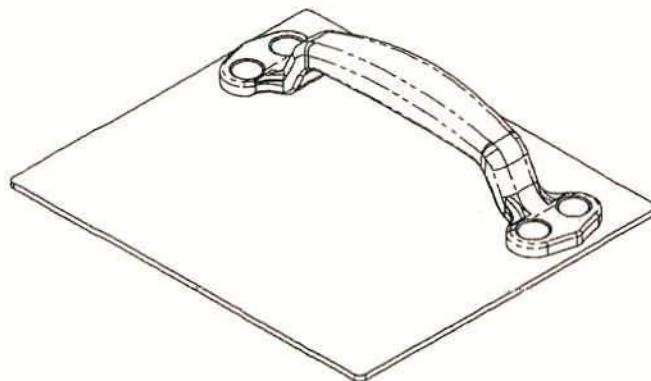
D3779-7: 0.38 lbs

8) BEND HANDLE THROUGH THIS AREA ONLY

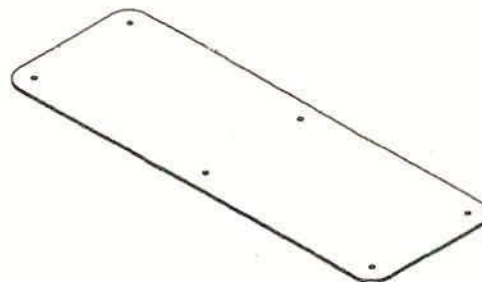
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2012-07-23

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CHECKED	A.P.	DRAWING NO.	REV. C
MFG. APPR.		D3779	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		HANDLE ASSEMBLY, CABIN SLIDING DOOR	
DATE	12.04.26	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE LOANED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE EXPRESS WRITTEN PERMISSION OF DART AEROSPACE LTD.	

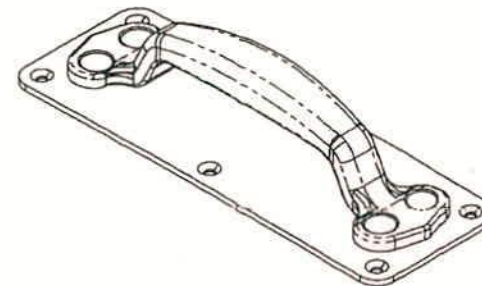
QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
X		D3779-041	HANDLE ASSEMBLY
	X	D3779-043	HANDLE ASSEMBLY
	1	D3203-1	HANDLE
1		D3779-1	PLATE
1	1	D3779-5	PLATE
1		D3779-7	HANDLE
4	4	MS20426AD10-9A	RIVET, CSK



**D3779-043 HANDLE ASSEMBLY
(INTERIOR)**



D3779-3 DOUBLER PLATE



**D3779-041 HANDLE ASSEMBLY
(EXTERIOR)**

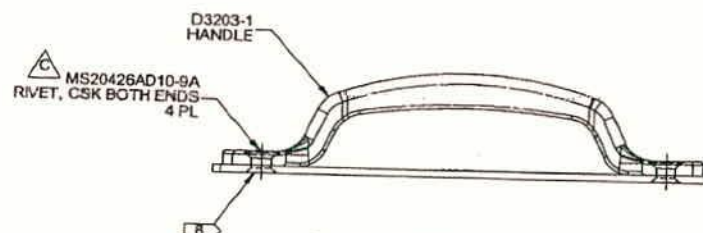
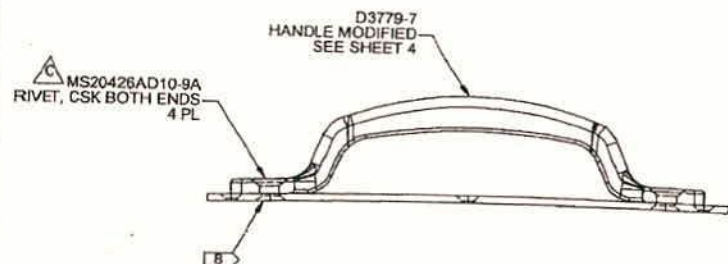
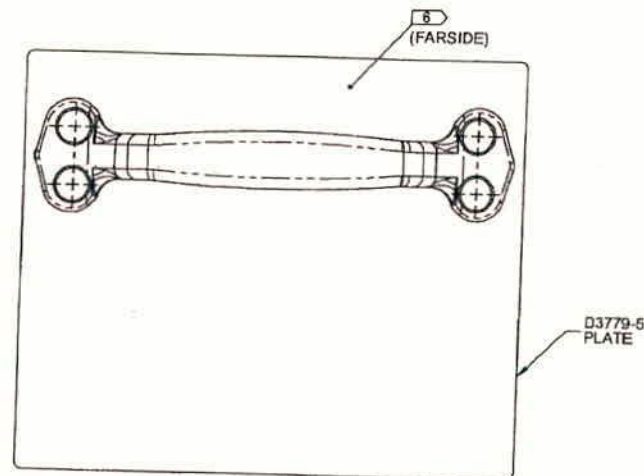
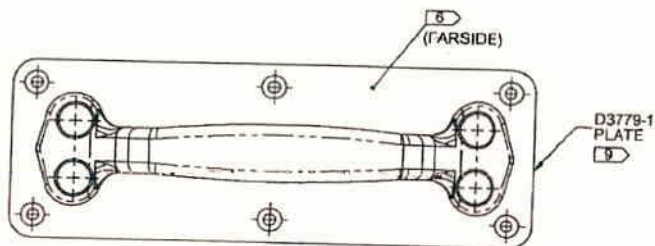
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: (SEE SHEETS 2 & 3)
- 7) WEIGHT: D3779-3: 0.14 lbs
D3779-041: 0.71 lbs
D3779-043: 1.14 lbs

Handwritten: 474-11-2
126538

RELEASED
2012-07-23
Handwritten signature: mp

C	CHANGED RIVET FROM -8 TO -9A CHANGED D3779-041 FROM FLAT TO CONTOURED	RP	12.04.20
B	REFORMAT IAW DART QSI 043: MS20426AD10-9 WAS REASON: MS20426AD10-8 (2N D6-1, B894-2) PRODUCTION FACILITY (PAR11-136)	MB	11.11.24
A	NEW ISSUE	AJS	08.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAYKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	A.P.	DRAWING NO.	REV. C
MFG. APPR.	<i>Handwritten signature</i>	D3779	SHEET 1 OF 4
APPROVED	<i>Handwritten signature</i>	TITLE	HANDLE ASSEMBLY, SCALE
DE APPR.	<i>Handwritten signature</i>	CABIN SLIDING DOOR	NTS
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**D3779-041 HANDLE ASSEMBLY
(EXTERIOR)**

**D3779-043 HANDLE ASSEMBLY
(INTERIOR)**

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3779-XXX" AND B/N "BXXXXX" PER DART QSI 044 6.1
 - 7) WEIGHT: D3779-041: 0.71 lbs
D3779-043: 1.14 lbs
 - 8) RIVETS TO BE PEENED AND GROUND FLUSH
 - 9) FORMED TO FIT D3779-7 HANDLE DURING ASSEMBLY.

RELEASED
2012-07-23

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. C
MFG. APPR.	AP	D3779	SHEET 2 OF 4
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	HANDLE ASSEMBLY, CABIN SLIDING DOOR	NTS
DATE	12.04.26	COPYRIGHT © 2008 BY DART AEROSPACE LTD	

